

Date: Thursday, 6/15/2006 1:52:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 27598
 Estimate Number : 10534
 P.O. Number : NIA Part Number : D2574
 This Issue : 6/15/2006 S.O. No. : NIA Drawing Number : D2574 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 27059 Material : NIA Due Date : 6/30/2006 Qty: 12 Um: 8 Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06-06-15
 Comment : Est Rev: 1 As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: 023940

3 24069 x 5

3.6

06/06/19

x 12

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 21598 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

3.6 / En

06/06/25 x 12

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

3.6 / En

06/06/25 x 12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.6 / En

06/06/25 x 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/06/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:52:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

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Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/06/26

12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-28

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-06-29

12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Paul 06/29

12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 480*

06-06-30

12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/06/30

12

Job Completion



U 06/06/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27598
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.749	1.748	1.747	1.747		
C	3.495	3.505		3.498	3.499	3.497	3.496		
D	1.745	1.755		1.745	1.748	1.747	1.748		
E	7.990	8.010		8.004	8.003	8.002	8.003		
F	0.490	0.510		0.492	0.493	0.494	0.495		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.498	0.497	0.498		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.566	0.566	0.567	0.567		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.367	1.369		
N	2.495	2.505		2.497	2.498	2.497	2.498		
O	4.119	4.129		4.121	4.120	4.121	4.120		
P	0.115	0.135		0.125	0.126	0.127	0.129		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.254	0.254	0.255		
S	0.115	0.135		0.119	0.119	0.120	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.235	0.235	0.236		
W	0.115	0.135		0.121	0.120	0.122	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.364	0.367	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.675	0.634	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.241	0.240		
AE	1.500	1.520		1.513	1.514	1.512	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.246	0.247	0.248		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G
Date:	06/06/23

Audited by:	AME
Date:	06/06/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 27598
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.747	1.746	1.746		
C	3.495	3.505		3.500	3.499	3.496	3.500		
D	1.745	1.755		1.748	1.747	1.746	1.746		
E	7.990	8.010		8.002	8.000	8.003	8.002		
F	0.490	0.510		0.499	0.499	0.496	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.499	0.498	0.493		
J	1.174	1.184		1.179	1.179	1.174	1.174		
K	0.558	0.578		0.569	0.568	0.560	0.562		
L	1.174	1.184		1.179	1.179	1.174	1.174		
M	1.365	1.375		1.371	1.371	1.366	1.368		
N	2.495	2.505		2.498	2.498	2.497	2.496		
O	4.119	4.129		4.121	4.122	4.118	4.121		
P	0.115	0.135		0.130	0.129	0.124	0.123		
Q	0.115	0.135		0.129	0.130	0.135	0.135		
R	0.240	0.260		0.249	0.250	0.249	0.251		
S	0.115	0.135		0.128	0.127	0.119	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.230		
V	0.230	0.250		0.241	0.244	0.233	0.233		
W	0.115	0.135		0.121	0.122	0.125	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.364	0.362	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.247	0.242	0.244		
AE	1.500	1.520		1.511	1.512	1.513	1.512		
AF	0.115	0.135		0.120	0.121	0.135	0.135		
AG	0.240	0.280		0.249	0.248	0.260	0.260		
AH	0.240	0.260		0.251	0.251	0.245	0.244		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G. / Sp
Date: 06/06/26

Audited by: TWL
Date: 06/06/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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B	1.745	1.755		1.745	1.749	1.747	1.749		
C	3.495	3.505		3.497	3.497	3.500	3.498		
D	1.745	1.755		1.745	1.749	1.747	1.749		
E	7.990	8.010		8.003	8.002	8.003	8.002		
F	0.490	0.510		0.498	0.502	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.498	0.498	0.495		
J	1.174	1.184		1.176	1.176	1.179	1.176		
K	0.558	0.578		0.561	0.564	0.565	0.562		
L	1.174	1.184		1.176	1.176	1.179	1.176		
M	1.365	1.375		1.366	1.369	1.370	1.367		
N	2.495	2.505		2.496	2.497	2.497	2.498		
O	4.119	4.129		4.120	4.123	4.126	4.123		
P	0.115	0.135		0.124	0.122	0.124	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.250	0.253		
S	0.115	0.135		0.121	0.117	0.117	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.237	0.237	0.238		
W	0.115	0.135		0.127	0.123	0.121	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.363	0.365	0.370		
AA	0.470	0.530		0.500	0.500	0.502	0.500		
AB	0.615	0.635		0.621	0.627	0.627	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.244	0.243		
AE	1.500	1.520		1.511	1.511	1.511	1.514		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.245	0.249	0.245	0.245		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

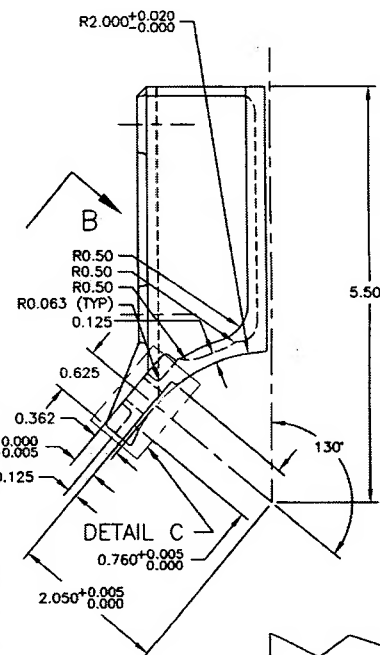
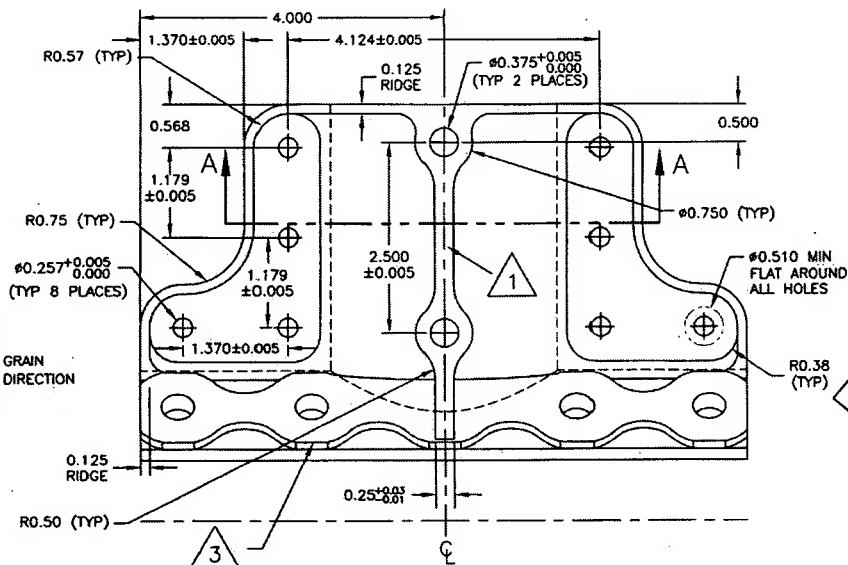
Measured by: <i>EP</i>
Date: 06/06/25

Audited by: <i>gml</i>
Date: 06/06/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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RELEASED

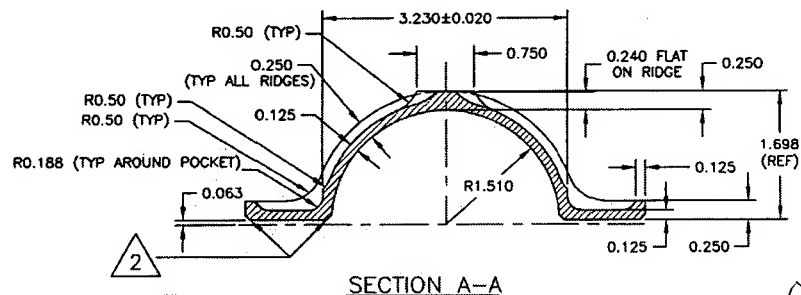
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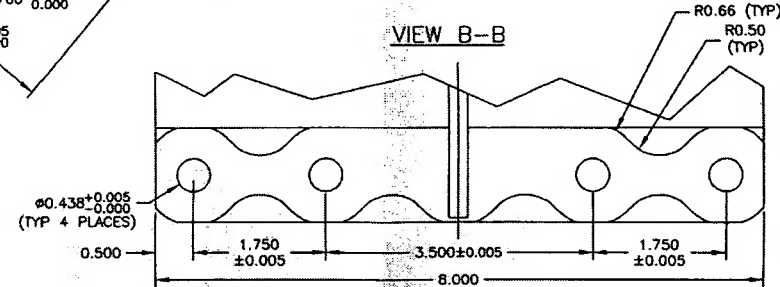
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

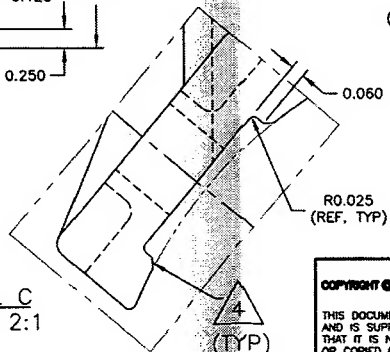
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



SECTION A-A



VIEW B-B



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	✓	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE
		DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
		DRAWING NO. D2574
		REV. E
		SHEET 1 OF 1
		SCALE 2:3

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NO. 27598